AMENDMENT TO THE SPECIFICATION

Replace paragraph 0020 with the amended paragraph as follows:

[0020] In the second stage of the process, the diameter of the drum, in its central section, is increases from the value D to the value D_1, equal to 1.1 D (see Figures 4 and 4A). By making the carcass ply 1 adhere to its radial reinforcement elements and the ply N, which is less wide, and with its oblique reinforcement elements, after extension in the circumferential direction, caused by the increase in diameter of the drum, there is obtained a change in the angles formed with the circumferential direction by the reinforcement elements of the two plies, in that section where the two plies adhere, whereas the angle is not changed in that part where only the carcass ply 1 is present. Upon this pre-shaping, the axial width L_0 of the shaping ply N decreases to L_1 (see Figure 4). As shown in Figure 4A, the elements of the ply N retain the same orientation, but the angle α_0 decreases to α_1, whereas the elements 10 of the carcass ply, in the major part of the width L_1, where there is adhesion, are oriented in the opposite direction to form an angle $-\beta_1$. The values of the angles α_1 and β_1 will obviously depend on the starting values, and the amount of the circumferential extension τ . Such values may be calculated approximately by the formulae:

$$\cos \alpha_1 = \frac{\sin(\beta_0 + \alpha_0) + \sin(\beta_0 - \alpha_0)\tau^2}{2\tau \, \sin\beta_0} \qquad \text{Eq. (1)}$$

with $0 \leq \alpha_0 < \beta_0 < \alpha_0 < 180°$

$$\text{and} \quad \frac{\sin \beta_1}{\sin \beta_0} = \frac{\sin \alpha_1}{\sin \alpha_0} \qquad \text{Eq. (2)}$$